

12319

6/6

Dart Aerospace Ltd.

Date: Tuesday, 7/17/2007 2:00:08 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CROSS BEAM
Job Number : 33586	
Estimate Number : 11026	
P.O. Number :	Part Number : D2764
This Issue : 7/17/2007 S.O. No. :	Drawing Number : D2764 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 29885	Material :
Written By :	Due Date : 8/24/2007 Qty: 4 Um: Each
Checked & Approved By : <u>07.07.17</u>	
Comment : Est. D 0008.14 Added note at step #1 EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6B1000X02500

6061-T6 Bar 1.0" x 2.5"



Comment: Qty.: 4.2875 f(s)/Unit Total: 17.1499 f(s)

6061-T6 Bar 1.0" x 2.5"

Material: 1" X 2.5" 6061-T6 (QQ-A-200/8)

Batch No: 7103039 SA (4)

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut Blanks: 48.5"

*** RUN D2796 WITH SAME PROG. *** SA 08/03/15 (4)

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per Folio D2764

Deburr H.A.P.M.R. 09/03/30 (4)

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE H.A.P.M.R. 08/03/30 (4)

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1 BL 08-03-31 (4)

4.1 QC8 Second Check. 080331 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/17/2007 2:00:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSS BEAM

Job Number: 33586

Part Number: D2764

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M10700 S



4X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1

08/04/01

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



4

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/04/01

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

SDub

LC 8/4 01 (4)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF

08-04-02

h

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	33586
Description: Cross Beam		Part Number:	D2764
Inspection Dwg: D2764/D2796		Rev: D/C	Page 1 of 1

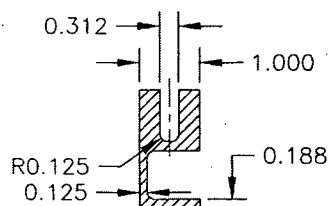
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

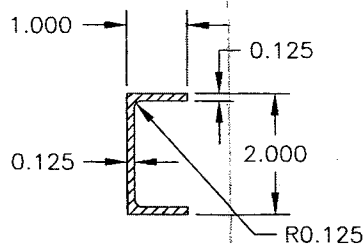
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.600	+/-0.010					JUST FOR D2796
1.690	+/-0.010					JUST FOR D2796
0.312	+/-0.010	0.316	✓			
1.000	+/-0.010	1.009	✓			
0.125	+/-0.010	0.131	✓			
0.188	+/-0.010	0.188	✓			
0.125	+/-0.010	0.125	✓			
2.000	+/-0.010	1.9955	✓			
0.438	+/-0.010	0.439	✓			
5.02	+/-0.030	5.020	✓			
11.950	+/-0.010	11.947	✓			
3.750	+/-0.010	3.751	✓			
Ø0.257	+0.006/-0.001	0.260	✓			
0.438	+/-0.010	0.436	✓			
47.40	+/-0.030	47.40	✓			
31.000	+/-0.010	31.000	✓			
15.500	+/-0.010	15.499	✓			
1.15	+/-0.030	1.1495	✓			
R0.438	+/-0.010	R0.438	✓			

Measured by:	<i>H.A / [Signature]</i>	Audited by:	<i>DTP</i>	Prototype Approval:	N/A
Date:	08/03/30	Date:	08/03/31	Date:	N/A

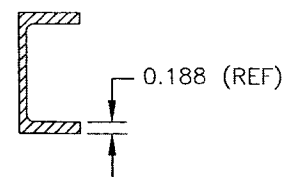
Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	



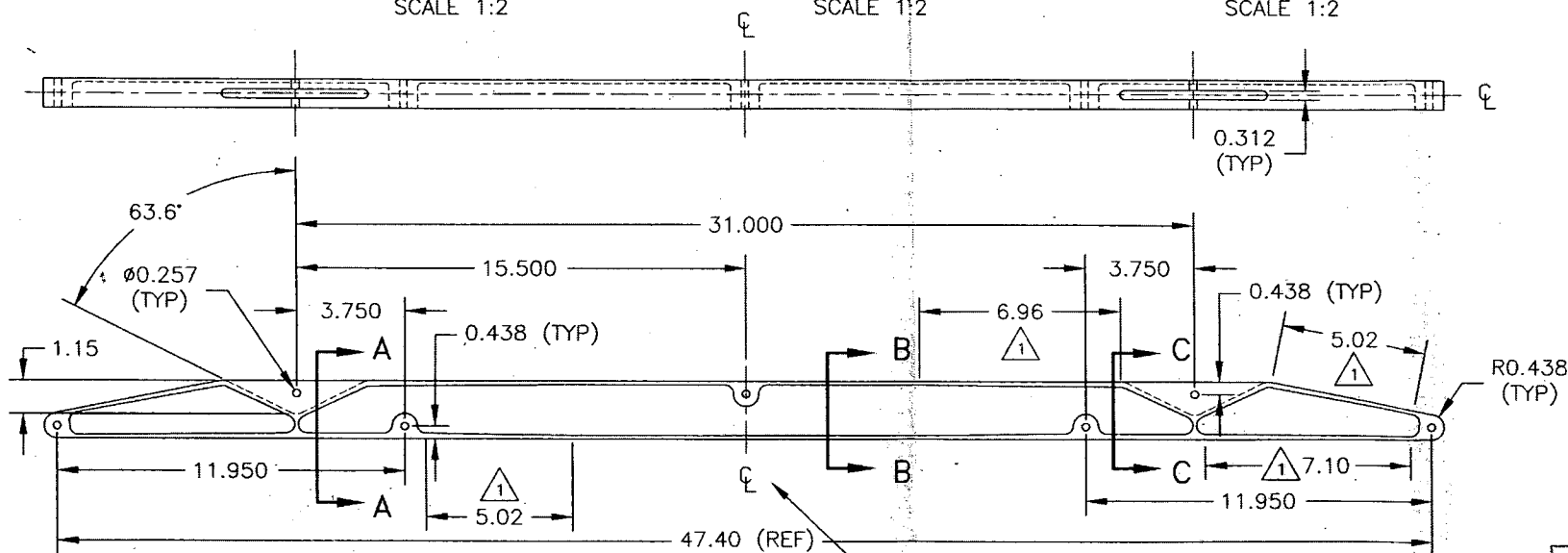
SECTION A-A
SCALE 1:2



SECTION B-B
SCALE 1:2



SECTION C-C
SCALE 1:2



PART IS SYMMETRIC
ABOUT THIS CENTER LINE

RELEASED
98.11.18 KE

EFFECTIVE DEOS

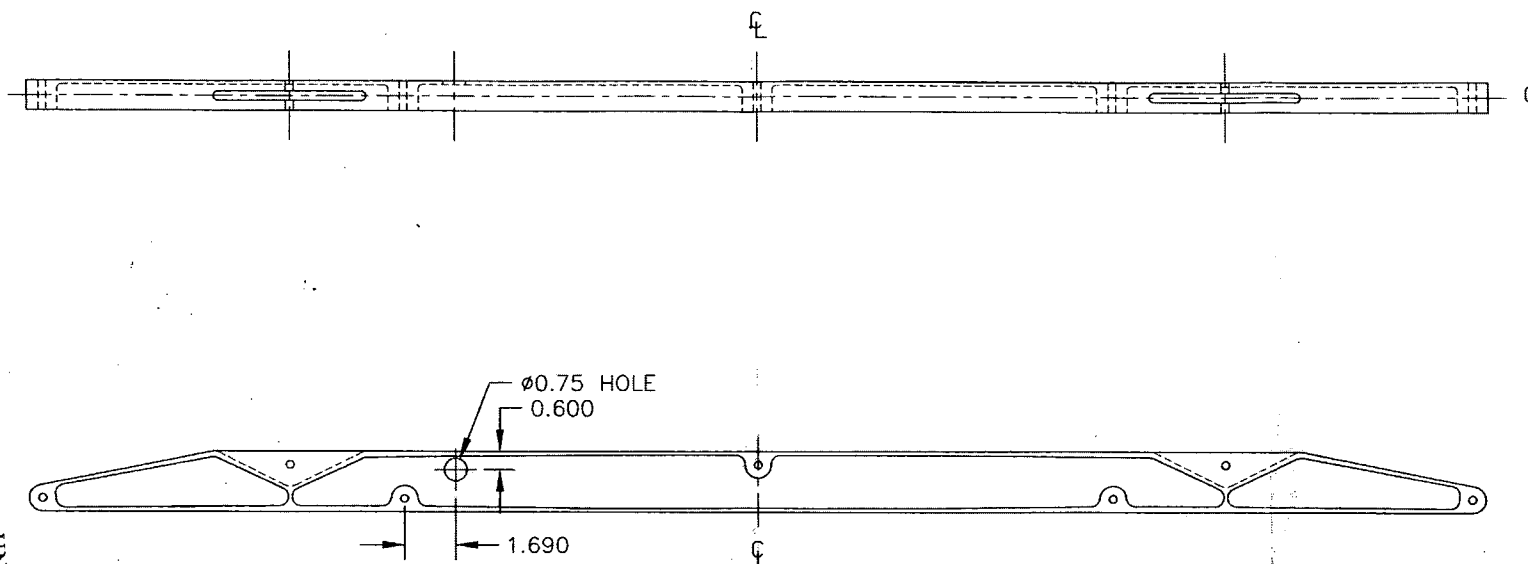
9126

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 33586
RETURN TO
ENGINEERING
SHOP COPY

MATERIAL: 6061-T6 (QQ-A-200/8) OR: (QQ-A-250/11) OR: (QQ-A-225/8) KE 98.12.03 FOR A(09)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

1 TAPERED WALL THICKNESS FROM 0.188 TO 0.125 OVER INDICATED LENGTH

D	98.11.09	TAPERED WALLS ADDED
C	98.09.01	MACHINED PART WAS BOX BEAM
B	98.06.17	ADD LARGE HOLES & STIFFENER
A	98.04.14	NEW ISSUE
DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA
CHECKED #	APPROVED S	DRAWING NO. D2764
DATE 98.11.09	TITLE CROSS BEAM	REV. D SHEET 1 OF 1 SCALE 1:4



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 33586

MATERIAL: MAKE FROM D2764
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
 99.11.19 KE



C	98.11.09	REMOVED WIRE SLOT, TAPERED WALLS
B	98.09.02	MACHINED PART WAS BOX BEAM
A	98.06.30	NEW ISSUE
DESIGN	KE	DART DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA
CHECKED	KE	DRAWING NO. D2796
DATE	98.11.09	TITLE MIDDLE CROSS BEAM
		REV. C SHEET 1 OF 1 SCALE 1:4

